



## Tip Selection

SOFTWARE / PRODUCT / FINISHING

To minimize build time and ensure feature details are built, it is important to select the correct tip size for each part. Using too small a tip on a part can significantly increase build times. Example: a part with a 5" z-axis dimension will have 500 layers using a T16 tip, 715 layers using a T12 tip (a 43% increase), and 1000 layers using a T10 tip (a 100% increase).

### Process

Determining the part size

**STEP 1:** Determine the size of the part; x, y and z dimensions. Remember that Insight displays measurement information in the bottom-right corner. General rule of thumb is:

- Parts 6" or larger use T16 tip
- Parts 3-6" use T12 tip
- Parts 3" or smaller use T10 tip
- Measure Wall thickness, boss diameters etc.

**STEP 2:** By measuring the smallest part features in Insight, such as wall thickness, boss diameters and other features road-widths can be determined.

- A. View Road-width measurements in Insight by right-clicking in the graphics window and selecting Measure (figure 1)

#### NOTE

Remember that each material and tip size has an associated range of road-widths besides the default. For example, a Titan T16 ABS tip has a range of road-widths from 0.016" to 0.032". The default is set at 0.020" (reference table in Insight User Guide). To see the range of contour and raster widths available for the tip selected,

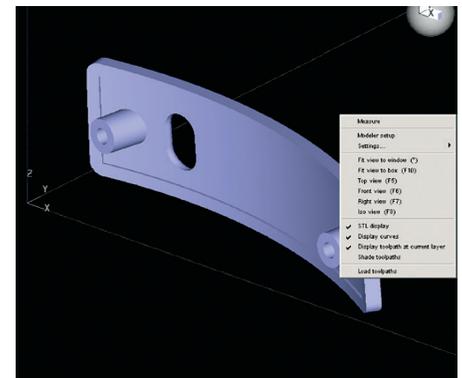


Figure 1: Measure Part



## CONTACT

For questions about the information contained in this document, contact Stratasys at [www.stratasys.com/contact-us/contact-stratasys](http://www.stratasys.com/contact-us/contact-stratasys).



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